



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D5423-1**

**Job Sheet 177841**



**Part No:** D5423-1

**Job Qty:** 4 ea **21**  
9-09

**Part Name:** Bearpaw



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 5/18/18

**Job Tracking No:**

**Due Date:** 5/25/18

**Created By:** Michelle Gagnon-Donovan

**Type:** Stock

**Description:**

**Note:** DWG REV A IPP REV:A NEW ISSUE JLM VERIFIED BY:DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off       |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------|
|       |                        |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                |
| 90    | Start up Operation     | 6 Ea  | 5/25/18    | 5/25/18  | 0.00      | 0.00    | Start Up Waterjet     |           | ac 18/05/19    |
| 120   | Waterjet               | 6 pcs | 5/25/18    | 5/25/18  | 0.00      | 7.89    | Waterjet1             |           | ac 18/05/19    |
| 130   | CNC Vertical Machining | 6 pcs | 5/25/18    | 5/25/18  | 0.96      | 33.33   | HAAS1-1               |           | DAS 18/06/20   |
| 140   | QC                     | 6 pcs | 5/25/18    | 5/25/18  | 0.00      | 0.00    | QC2 Machining-4       |           | 52 18/06/20    |
| 150   | QC                     | 6 pcs | 5/25/18    | 5/25/18  | 0.00      | 0.00    | QC8 Machining-4       |           | 9-89 18/06/20  |
| 160   | Packaging              | 6 pcs | 5/25/18    | 5/25/18  | 0.00      | 0.00    | Packaging3            | 57479A    | JUL 02 2018 SV |
| 170   | QC21-SA                | 6 Ea  | 5/25/18    | 5/25/18  | 0.00      | 0.00    | QC21                  |           | JUL 02 2018 SV |

Part Op 120 - Cut Blank as per D5423-1 blank file

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FB481 and Dwg D5423

### Job BOM

| Part / Item | Component Name    | Quantity     | Operation             | Container |
|-------------|-------------------|--------------|-----------------------|-----------|
| MUHMWB1.250 | UHMWB 1.250 BLACK | 42 sf (7 ea) | 90-Start up Operation |           |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | MUHMWB1.250    | 42       | 29        | 0         |

### Part Specifications

Specifications could not be found.

Plex 5/18/18 12:37 PM Dart.Gagnon.Michelle



Container No: S072729



Part: D5423-1

Job No: 177841

Serial No/Batch: S072729

Revision:

Inspector:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 813 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 05/19/18

|                                            |  |                             |
|--------------------------------------------|--|-----------------------------|
| <b>DART AEROSPACE LTD</b>                  |  | <b>Work Order:</b> 177841   |
| <b>Description:</b> Bearpaw                |  | <b>Part Number:</b> D5423-1 |
| <b>Inspection Dwg:</b> D5423 <b>Rev:</b> A |  | Page 1 of 1                 |

### INSPECTION SHEET

| Drawing Dimension | Tolerance    | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|--------------|------------------|--------|--------|----------------------|----------|
| Ø .261            | -.001 + .005 | .261             | ✓      |        | G.P.                 |          |
| Ø .93             | ± .03        | .930             | ✓      |        | Ver                  |          |
| .30               | ± .03        | .312             | ✓      |        | D.G.                 |          |
| .06x45°           | ±.03x ±.5°   | .06x45°          | ✓      |        | Ver                  |          |
| .38               | ± .03        | .38              | ✓      |        | Ver                  |          |
| 1.00              | ± .01        | 1.00             | ✓      |        | Ver                  |          |
| 8.50              | ± .01        | 8.50             | ✓      |        | TAPE                 |          |
| 21.75             | ± .01        | 21.75            | ✓      |        | TAPE                 |          |
| 32.00             | ± .01        | 32.00            | ✓      |        | TAPE                 |          |
| 33.50             | ± .01        | 33.50            | ✓      |        | TAPE                 |          |
| 41.06             | ± .01        | 41.06            | ✓      |        | TAPE                 |          |
| 5.000             | ± .01        | 5.005            | ✓      |        | Ver                  |          |
| 2.500             | ± .01        | 2.500            | ✓      |        | Ver                  |          |
| 2.300             | ± .01        | 2.300            | ✓      |        | Ver                  |          |
| 4.600             | ± .01        | 4.600            | ✓      |        | Ver                  |          |
| 44.50             | ± .03        | 44.50            | ✓      |        | TAPE                 |          |
| 6.70              | ± .03        | 6.70             | ✓      |        | Ver                  |          |
| 1.63              | ± .03        | 1.63             | ✓      |        | Ver                  |          |
| 4.13              | ± .03        | 4.13             | ✓      |        | Ver                  |          |
| 5.82              | ± .03        | 5.82             | ✓      |        | Ver                  |          |
| R.0.50            | ± .03        | R.0.50           | ✓      |        | R.G.                 |          |
| 6.62              | ± .03        | 6.62             | ✓      |        | Ver                  |          |
| 19.00             | ± .03        | 19.00            | ✓      |        | TAPE                 |          |
| 11.74             | ± .03        | 11.74            | ✓      |        | TAPE                 |          |
| 1.20              | ± .03        | 1.30             | ✓      |        | Ver                  |          |
| .950              | ± .03        | .960             | ✓      |        | Ver                  |          |
| .750              | ± .03        | .760             | ✓      |        | Ver                  |          |
| 0.25              | ±.03 - .01   | 0.255            | ✓      |        | Ver                  |          |
| .04x45°           | ±.03x ±.5°   | .04x45°          | ✓      |        | Ver                  |          |
| .25x45°           | ±.03x ±.5°   | .25x45°          | ✓      |        | TAPE                 |          |
| 1.44              | ± .03        | 1.44             | ✓      |        | Ver                  |          |
| 0.37              | ±.03 ±.01    | 0.385            | ✓      |        | Ver                  |          |

|                        |                                |                      |
|------------------------|--------------------------------|----------------------|
| <b>Measured by:</b> 52 | <b>Checked by:</b> [Signature] | <b>QC Inspector:</b> |
| <b>Date:</b> 18/06/20  | <b>Date:</b> 18/07/03          | <b>Date:</b>         |

|                                                |              |
|------------------------------------------------|--------------|
| <b>Engineering Approval:</b><br>(If necessary) | <b>Date:</b> |
|------------------------------------------------|--------------|

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| B   | 14.07.31 | New Issue | KJ         |          |